

Date: Friday, 12/9/2005 11:45:52 AM
 User: Kim Johnston

Process Sheet

SPLIT L

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 25185 -2
 Estimate Number : 10788
 P.O. Number : NIA
 This Issue : 12/9/2005 S.O. No. : NIA
 Prsht Rev. : NC
 First Issue : 12/9/2005 Type : PURCHASED PARTS
 Previous Run : 25071
 Written By : SEE COMMENT BELOW
 Checked & Approved By : SEE ABOVE USER
 Comment : Est Rev:A New Issue 05-11-10 EC

Drawing Name : WEARPAD
 Part Number : D33393
 Drawing Number : D3339 REV B
 Project Number : N/A
 Drawing Revision : B
 Material : NIA
 Due Date : 12/30/2005 Qty: 80 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0

PG

PURCHASING



Comment: Issue P/O: 00000267
 E-mail or Ship DXF file to vendor
 Laser cut flat pattern as per Dwg
 Possible supplier: Ind. Laser
 Material release note is required.

Alos 12/12

2.0

D33393F

WEARPAD-FLAT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 80.0000 Each(s)
 WEARPAD-FLAT

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Receive & Inspect For Transit Damage
 Ensure material certification is attached

DL 05/12/30 80

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

PR 06-01-03

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Deburr if necceray

2-Form as per Dwg D3339 using DT8326 and DT8261

SB 06/01/04 79

Process Sheet

Order: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 25185

Part Number: D33393

Job Number:



Seq. #: Machine Or Operation: Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



J 06.01.04 (39)

Comment: INSPECT WORK TO CURRENT STEP

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld Hard coat 7560 per Dwg D3339, use DT8210 & DT8810 Layout Jig

CPL 06.02.20 (39)

A/R 7560 Hardcoat

Batch: M1174 M19682

~~CPL 06.01.05~~ (39)

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

06/02/20 (39)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

FC 06.02.21 39

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M 06.02.22 (39)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5727

06/21/22 (39)

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/02/23

Job Completion



u 06.02.23

2094 304 0455 (0.037)
PO 267 196

YIH MAU CORP.
246, SHAN AN RD, WU CHU HSIANG
KAO-HSIUNG TAINAN R.O.C.
TEL: (07) 8722445 FAX: (07) 8722000
CERTIFICATE NO: 0011182
DATE OF ISSUE: 1/14/2004

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN MADE IN ACCORDANCE WITH THE RULES OF THE MILL CERTIFICATE.
PRODUCT IN ACCORDANCE WITH ASTM A340, A480, A592, ASME SA400, Q375RD.

ITEM NO.	SIZE	NO.	Weight (N.W.)	Heat No.	ID NO.	Physical Properties										Chemical Composition (%)				
						YS	TS	EL	HRB	HV	C	Si	Mn	P	S	N	O	M		
ASIS 304.2B	(0.05-0.28)	1	1.465	3.230	YU231320	3AS44463B-21	258	665	56	81	166	4.8	51	119	24	2	804	1821	2.7	2.7
20GA/80TX30	(0.05-0.28)	1	1.464	3.228	YU231320	3AS44463B-22	258	665	56	81	156	4.8	51	119	24	2	804	1821	2.7	2.7
20GA/80TX30	(0.05-0.28)	1	1.464	3.228	YU230510	36637608B-61	280	673	53	82	162	5.4	50	126	26	3	816	1819	2.4	2.4
20GA/80TX30	(0.05-0.28)	1	1.464	3.228	YU230510	36637608B-62	280	673	53	82	162	5.4	50	126	26	3	816	1819	2.4	2.4
20GA/80TX30	(0.05-0.28)	1	1.575	3.081	YU230510	36637608B-62	280	673	53	82	162	5.4	50	126	26	3	816	1819	2.4	2.4
20GA/80TX30	(0.05-0.28)	1	1.465	3.230	YU231066	3AS42732-6	301	664	49	84	166	3.7	40	116	27	5	810	1824	3.7	3.7
20GA/80TX30	(0.05-0.28)	1	1.457	3.300	YU231066	3AS42732-4	301	664	49	84	166	3.7	40	116	27	5	810	1824	3.7	3.7
20GA/80TX30	(0.05-0.28)	1	1.455	3.208	YU231066	3AS42732-0	301	664	49	84	166	3.7	40	116	27	5	810	1824	3.7	3.7
20GA/80TX30	(0.05-0.28)	1	1.453	3.187	YU231143	3AS42866A-6	302	650	53	82	159	4.5	52	123	26	4	810	1822	2.7	2.7
20GA/80TX30	(0.05-0.28)	1	1.454	3.199	YU231143	3AS42866A-7	302	650	53	82	159	4.5	52	123	26	4	810	1822	2.7	2.7
20GA/80TX30	(0.05-0.28)	1	1.450	3.131	YU231143	3AS42866B-1	302	650	53	82	159	4.5	52	123	26	4	810	1822	2.7	2.7
20GA/80TX30	(0.05-0.28)	1	1.441	3.177	YU231075	3AS42817A-1	302	650	52	83	162	4.2	46	118	28	6	808	1813	3.4	3.4
20GA/80TX30	(0.05-0.28)	1	1.441	3.177	YU231075	3AS42817A-2	302	650	52	83	162	4.2	46	118	28	6	808	1813	3.4	3.4
20GA/80TX30	(0.05-0.28)	1	1.420	3.131	YU231075	3AS42917A-3	302	650	52	83	162	4.2	46	118	28	6	808	1813	3.4	3.4
20GA/80TX30	(0.05-0.28)	1	1.420	3.131	YU231075	3AS42917A-4	302	650	52	83	162	4.2	46	118	28	6	808	1813	3.4	3.4
20GA/80TX30	(0.05-0.28)	1	1.446	3.188	YU232202	3AS45623A-211	301	641	53	81	157	5.1	51	114	30	9	806	1822	3	3
20GA/80TX30	(0.05-0.28)	1	1.405	3.097	YU232202	3AS45623A-212	301	641	53	81	157	5.1	51	114	30	9	806	1822	3	3
20GA/80TX30	(0.05-0.28)	1	1.540	3.395	YU232202	3AS45623A-214	301	641	53	81	157	5.1	51	114	30	9	806	1822	3	3

INSPECTION CERTIFICATE
MATERIAL : / INSPECTION CERTIFICATES
YIH MAU CORP.
PO BOX 100
FENGHOLD ROLLED STAINLESS STEEL SHEET AISI 304ND4 (S10)
FINISH WITH 100 MESH ON MAIN SIDE, WITH BACK PASS.
SLITTED EDGE AND 304.2B FINISH WITH PAPER INTERLEAVED.
SLITTED EDGE.
INSPECTION NO. 0011182
DATE OF ISSUE: 1/14/2004

NEW ZEALAND
STEEL

New Zealand Steel Limited
Glenbrook, South Auckland
Postal: Private Bag 92121, Auckland, New Zealand
Telephones: (09) 375 8998 / 375 5111 Auckland
(09) 235 8080 / 235 3535 Waiuku
Fax: (09) 375 8859

TEST CERTIFICATE

Ref: S210/22495

CUSTOMER	Wilkinson	P50323 DI001	SPECIFICATION	ASTMA1008 CS Type A	CERTIFICATE No	TC112397
CUSTOMER O/N	98-21N-686		PRODUCT	CRA WIDE COIL	PAGE	1 of 1
MILL O/N	480737		DIMENSIONS	0.055" x 48" x Coil	DATE	09 June 2005

PACK NUMBER	HEAT No	CHEMICAL COMPOSITION PERCENT															MECHANICAL TESTS (TEST SPECIFICATION - ASTM A370)							
		C	Si	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb	Ti	Al	B	N2	CE ()	BEND	YIELD	T.S.	%ELONG	HARDNESS	r	LENGTH
		x100			x1000										x10000		x100	180°				G.L.=	HRB	()
R9-459713-00	641758	4	TR	18	4	16	13	19	10	5	3	1	1					Good				54		1585
R9-459714-00	641758	4	TR	18	4	16	13	19	10	5	3	1	1					Good				54		1457
R9-459715-00	641513	5	TR	18	9	18	12	17	15	1	6	1	1					Good				48		1375
R9-459716-00	641513	5	TR	18	9	18	12	17	15	1	6	1	1					Good				48		1473
R9-459717-00	641756	5	TR	20	12	19	12	18	19	1	7	1	1					Good				48		1631
R9-459718-00	641756	5	TR	20	12	19	12	18	19	1	7	1	1					Good				48		1093
R9-459719-00	641756	5	TR	20	12	19	12	18	19	1	7	1	1					Good				50		1562
R9-459720-00	641756	5	TR	20	12	19	12	18	19	1	7	1	1					Good				50		1535
R9-460380-00	641761	4	TR	20	13	17	12	18	25	5	8	1	1					Good				50		1581
R9-460381-00	641758	4	TR	18	4	16	13	19	10	5	3	1	1					Good				49		1562
R9-460382-00	641758	4	TR	18	4	16	13	19	10	5	3	1	1					Good				49		1503
R9-461458-00	642309	2	TR	18	10	20	11	17	19	1	6	1	1					Good				48		1785

YIELD (A)=0.2% PROOF STRESS (B)=LOWER YIELD STRESS	GAUGE LENGTH (G.L.) (A)=200mm (C)=80mm (E)=2" (B)=50mm (D)=5.65 + So (F)=8"	PLASTIC STRAIN RATIO (r) (A)=r0 (C)=r45 (B)=r90 (D)=(r0+r90+2r45)/4	IMPACT TEST (A)=10mm x 10mm (B)=7.5mm x 10mm (C)=5mm x 5mm (D)=2.5mm x 10mm (E)=5mm x 10mm	CARBON EQUIVALENT VALUE (CE) (A)=C+Mn/8 (B)=C+Mn/6+(Cr+V+Mo)/5+(Cu+Ni)/15 (C)=C+Mn/6+Si/24 (D)=
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WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED
WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED *Atish Misra*
QC METALLURGIST

16 ga ms

POA 146, (267), 245,

PA: 227181
INV: 55031MD009